

# Work Order ID 53689

November 12, 2009 3:55:11 PM

Page 1

Item ID: D205-633-011

Accept

Revision ID: N/A

Item Name: Heli-Access-Step

Start Date: 11/12/09 Start Qty: 2.00

Required Date: 11/19/09 Req'd Qty: 2.00

Reference: Return 2009 / RA109111

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date: 09-11-12

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Original B47834 @ CHG001

110

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

Only Qty 1 new paper work required for 1 kit. New labels with the new batch #'s for both steps @ CHG001.  
Clean & return to stock.

120

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

|                                |  |     |             |
|--------------------------------|--|-----|-------------|
| <b>DART</b>                    |  |     |             |
| Dart Aerospace Ltd.            |  |     |             |
| 1270 ABERDEEN ST.              |  |     |             |
| HAWKESBURY, ON, CANADA K6A 1K7 |  |     |             |
| P/N                            |  | CHG | CHG001      |
| DESC.                          |  | STC | SH96-57     |
| LOT                            |  | STC | SR00592/3NY |
| MODEL                          |  | STC | SR00594NY   |

MADE IN CANADA

TC APPROVAL # 09-89  
TEL: 1-613-632-5200

|                                |                      |     |             |
|--------------------------------|----------------------|-----|-------------|
| <b>DART</b>                    |                      |     |             |
| Dart Aerospace Ltd.            |                      |     |             |
| 1270 ABERDEEN ST.              |                      |     |             |
| HAWKESBURY, ON, CANADA K6A 1K7 |                      |     |             |
| P/N                            | D205-633-011         | CHG | CHG001      |
| DESC.                          | Heli-Access-Step     | STC | SH96-57     |
| LOT                            | B47834               | STC | SR00592/3NY |
| MODEL                          | Bell 205/212/214/412 | STC | SR00594NY   |

MADE IN CANADA

TC APPROVAL # 09-89  
TEL: 1-613-632-5200

Case: Monday 11/05/2009 1:20:27 PM  
User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 STEP(STANDARD HEIGHT)  
 Job Number : 47834  
 Estimate Number : 10180  
 P.O. Number : Part Number : D205633011  
 This Issue : 11/05/2009 S.O. No. : Drawing Number : N/A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 1/1 Type : LARGE FAB ASSY Drawing Revision : N/A  
 Previous Run : 47744 Material :  
 Due Date : 28/05/2009 Qty: *split 6* Um: Each  
 Written By :  
 Checked & Approved By : *JUD 09.05.11*  
 Comment : Est Rev: F 02.07.11 Reformat; Removed D3010 RF

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP205-633-011 CH 6001

2.0

47834A

STEP WELDMENT



Comment: Sub-Component STEP WELDMENT

1x D2563 Batch *77834A*

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0

D2021101

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

| Qty | Part Number | Description | Batch         |
|-----|-------------|-------------|---------------|
| 1   | D2021-101   | Eyebolt     | <i>B40093</i> |

5.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

| Qty | Part Number | Description | Batch                    |
|-----|-------------|-------------|--------------------------|
| 2   | D2022-101   | Spacer      | <i>B41928x9 B45885x3</i> |

Date: Monday, 11/05/2009 1:20:27 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 47834

Part Number: D205633011

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D2022103

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2022-103 Spacer

B44353 ✓✓

SS 09/06/05 (X6)

7.0

D2562001

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2562-001 Strut

48108 ✓✓

9/6/10

SS

8.0

D2565101

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-101 Strut

B47484 x5

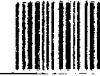
B47544 x1

SS 09/06/05 (X6)

9.0

D2565103

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-103 Strut

47545 ✓✓

SS 09/06/05 (X6)

10.0

D2565105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-105 Strut

47485 ✓✓

SS 09/06/05 (X6)

11.0

D2565107

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-107 Strut

B47547 ✓✓

SS 09/06/05 (X6)

Date: Monday, 11/05/2009 1:20:27 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dari Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 47834

Part Number: D205633011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2565109

Strut



"LWE"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
1 D2565-109 Strut 47548 ✓

SS 09/06/05 (x6)

13.0

D2565111

Strut



"LWE"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
1 D2565-111 Strut 47486 ✓

SS 09/06/05 (x6)

14.0

AN45A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
2 AN4-5A Bolt M111650 ✓

SS 09/06/05 (x6)

15.0

AN46A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
2 AN4-6A Bolt M110399 ✓

SS 09/06/05 (x6)

16.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
2 AN4-7A Bolt M110155 ✓

SS 09/06/05 (x6)

Date: Monday, 11/05/2009 1:20:28 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 47834

Part Number: D205633011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN414A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~10.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

① AN4-14A

Bolt

M110372

S (46)

SS 09/06/05 (X6)

18.0

AN55A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~10.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

① AN5-6A

Bolt

M111425

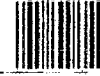
S (46)

SS 09/06/05 (X6)

19.0

AN514A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~10.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

① AN5-14A

Bolt

M109282

S (46)

SS 09/06/04 (X6)

20.0

AN960JD416

Washer



Comment: Qty.: 15.0000 Each(s)/Unit Total: ~~150.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

① AN960JD416

Washer

M111279

S (46)

SS 09/06/04 (X6)

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~40.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

④ AN960JD516

Washer

M111279

S (46)

SS 09/06/04 (X6)

Date: Monday, 11/05/2009 1:20:28 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP(STANDARD HEIGHT)

Job Number: 47834

Part Number: D205633011

Job Number:



Seq. #:

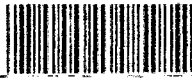
Machine Or Operation:

Description:

22.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut

M110450

23.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 Nut

M111127

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-011

Location:

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf  
09-06-10